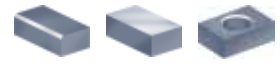
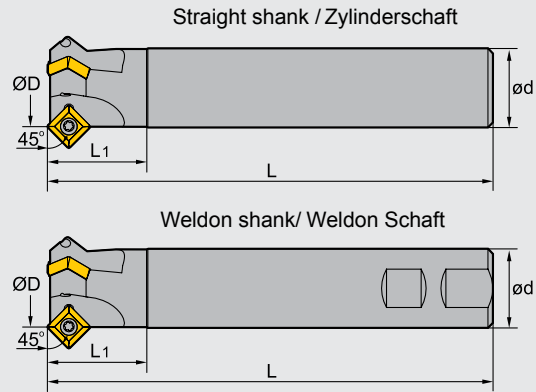


Kr:45°



### Chamfer milling tools · Fasfräser



**CMA01** P M K



### ■ Specification of tools · Werkzeug-Beschreibung

	Type Typ	Stock Lager	Dimensions (mm) Abmessungen				No. of teeth Zähne	Weight Gewicht (kg)
			Ø D	ø d	L	L <sub>1</sub>		
Straight shank	<b>CMA01</b> -012-G20-SP12-01	●	12	20	100	40	1	0.2
	-025-G25-SP12-02	●	25	25	120	40	2	0.8
Zylinder Schaft	<b>-032-G32-SP12-03</b>	●	32	32	180	40	3	1.1
Weldon shank	<b>-012-XP20-SP12-01</b>	●	12	20	100	40	1	0.2
Weldon Schaft	<b>-025-XP25-SP12-02</b>	●	25	25	120	40	2	0.6
	<b>-032-XP32-SP12-03</b>	●	32	32	100	40	3	1.0

### ■ Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Wrench Schlüssel
Ø12-Ø32	 I43M5×11	 WT20IS



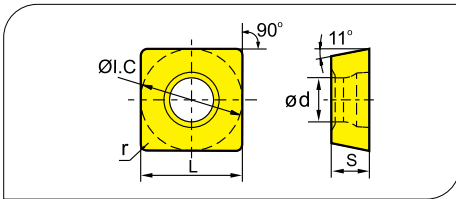
Applicable tool  
Werkzeug **B11-B18**

Tools code key  
Werkzeug ISO **B26-B27**

Grade selection guide  
Sortenauswahl **B19-B23**

Technical data  
Technische Daten **B215-B220**

### Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoff	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert WSP	Type Typ	Dimensions (mm) / Abmessungen					CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.				Cermet / Cermet	Carbide uncoat. / unbe. Hartmetall							
		I.C.	L	r	S	d	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101
	<b>SPMT120408</b>	12.7	12.7	0.8	4.76	5.5	●	○	●									●							

### Recommended Cutting data · Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten	
			Cutting speed / Schnittgeschw. (m/min)	Feed speed / Vorschub (mm/z)
<b>P</b> Low-carbon steel / Soft steel / niedriglegierter Kohlenstoffstahl / Baustahl  High-carbon steel / hochlegierter Kohlenstoffstahl / Alloy steel / Leg. Stahl  Alloy tool steel / Leg. Werkzeugstahl	≤180	YBM251 YBC301	180(100—250)	0.25 (0.1-0.4)
		YBM351 YBG302 YBC401	150(100—200)	0.3 (0.1-0.5)
		YC30S	120(80—150)	0.4 (0.1-0.5)
	180—280	YBM251 YBC301	160(100—220)	0.3 (0.1-0.4)
		YBM351 YBG302 YBC401	130(100—180)	0.3 (0.1-0.5)
		YC30S	100(60—150)	0.4 (0.1-0.5)
	280—350	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)
		YBM351 YBG302	100(80—150)	0.3 (0.1-0.5)
		YC30S	80(60—120)	0.4 (0.1-0.5)
<b>M</b> Stainless steel / Rostfreier Stahl	≤270	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)
		YBM351 YBG302 YBC401	100(80—150)	0.3 (0.1-0.5)
		YC30S	80(60—120)	0.4 (0.1-0.5)
<b>K</b> Cast iron / Gusseisen	180-250	YBG302	130(100—180)	0.4 (0.1-0.5)

Applicable tool / Werkzeug **B11-B18**

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Grade selection guide / Sortenauswahl **B19-B23**

Technical data / Technische Daten **B215-B220**